

# Quindos Measuring Report



3D-Application Center

Description	DRIFT TUBE 1	Customer	L. GARCIA
Drawing Number	PF-700-913-11 R3	Serial Number	007
Remarks		Article Number	
Supplier	KLYSTRON	Delivery Date	
Delivery Note		Delivery Volume	
Lot Number		Lot Size	
Test Schedule		Sample Size	
Production Machine		Production Tool	
Production Date		Production Time	
Order	8552100	Department	MET. QUALITY INSPEC
Inspector	kcaban	Inspection Date	20-OCT-2009, 09:40:45
Measuring Device	PMM 12 10 6 #496	Measuring Program	Quindos7 - V 7.1.9272-B
User Name	kcaban	WKP Name	NO\$NAME

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>DATUM_A</b>		<b>PLA</b>					
	FLATNS	0.00044	0.00000	0.00100	0.00000	0.00044	
<b>DATUM_B</b>		<b>CYL</b>					
	DM	0.37505	0.37500	0.00050	-0.00050	0.00005	
<b>CYL_B</b>		<b>CYL</b>					
	CYLFRM	0.00005	0.00000	0.00050	0.00000	0.00005	
<b>SQR_B</b>		<b>AXI</b>					
	SQRNES	0.00003	0.00000	0.00100	0.00000	0.00003	
<b>FEATURE(1)</b>		<b>CIR</b>					
	DM	0.99731	0.99800	0.00000	-0.00100	-0.00069	
<b>FEATURE(2)</b>		<b>AXI</b>					
	RADRUN	0.00006	0.00000	0.00100	0.00000	0.00006	
<b>FEATURE(3)</b>		<b>PLA</b>					
	Z	0.24167	0.24400	0.00000	-0.00500	-0.00233	
<b>FEATURE(6)</b>		<b>CYL</b>					
	FORM	0.00029					
	DM	0.28120	0.28100	0.00500	-0.00500	0.00020	
	X	-0.00539	0.00000			0.00539	
	Y	0.89892	0.90000			-0.00108	
<b>POS_FEATURE(6)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMMC	0.01104	0.00000	0.03491	0.00000	0.01104	
<b>FEATURE(7)</b>		<b>CYL</b>					
	FORM	0.00036					
	DM	0.28132	0.28100	0.00500	-0.00500	0.00032	
	X	-0.64012	0.63630			0.00382	
	Y	0.63158	0.63630			-0.00472	
<b>POS_FEATURE(7)</b>		<b>AXI</b>					
	POSITN			0.03000			

Text	Eval.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic

<b>POS_FEATURE(7)</b>		<b>AXI</b>					
POSMMC	0.01222	0.00000	0.03497	0.00000	0.01222		

<b>FEATURE(8)</b>		<b>CYL</b>					
FORM	0.00028						
DM	0.28113	0.28100	0.00500	-0.00500	0.00013		
X	-0.90007	0.90000			0.00007		
Y	-0.00639	0.00000			0.00639		

<b>POS_FEATURE(8)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01283	0.00000	0.03481	0.00000	0.01283		

<b>FEATURE(9)</b>		<b>CYL</b>					
FORM	0.00042						
DM	0.28128	0.28100	0.00500	-0.00500	0.00028		
X	-0.63274	0.63630			-0.00356		
Y	-0.64124	0.63630			0.00494		

<b>POS_FEATURE(9)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01218	0.00000	0.03485	0.00000	0.01218		

<b>FEATURE(10)</b>		<b>CYL</b>					
FORM	0.00027						
DM	0.28119	0.28100	0.00500	-0.00500	0.00019		
X	0.00510	0.00000			0.00510		
Y	-0.90113	0.90000			0.00113		

<b>POS_FEATURE(10)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.01050	0.00000	0.03489	0.00000	0.01050		

<b>FEATURE(11)</b>		<b>CYL</b>					
FORM	0.00038						
DM	0.28126	0.28100	0.00500	-0.00500	0.00026		
X	0.63997	0.63630			0.00367		
Y	-0.63379	0.63630			-0.00251		

<b>POS_FEATURE(11)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00896	0.00000	0.03488	0.00000	0.00896		

<b>FEATURE(12)</b>		<b>CYL</b>					
FORM	0.00028						
DM	0.28123	0.28100	0.00500	-0.00500	0.00023		
X	0.89985	0.90000			-0.00015		
Y	0.00413	0.00000			0.00413		

<b>POS_FEATURE(12)</b>		<b>AXI</b>					
POSITN			0.03000				
POSMMC	0.00832	0.00000	0.03495	0.00000	0.00832		

<b>FEATURE(13)</b>		<b>CYL</b>					
FORM	0.00040						
DM	0.28125	0.28100	0.00500	-0.00500	0.00025		
X	0.63262	0.63630			-0.00368		
Y	0.63902	0.63630			0.00272		

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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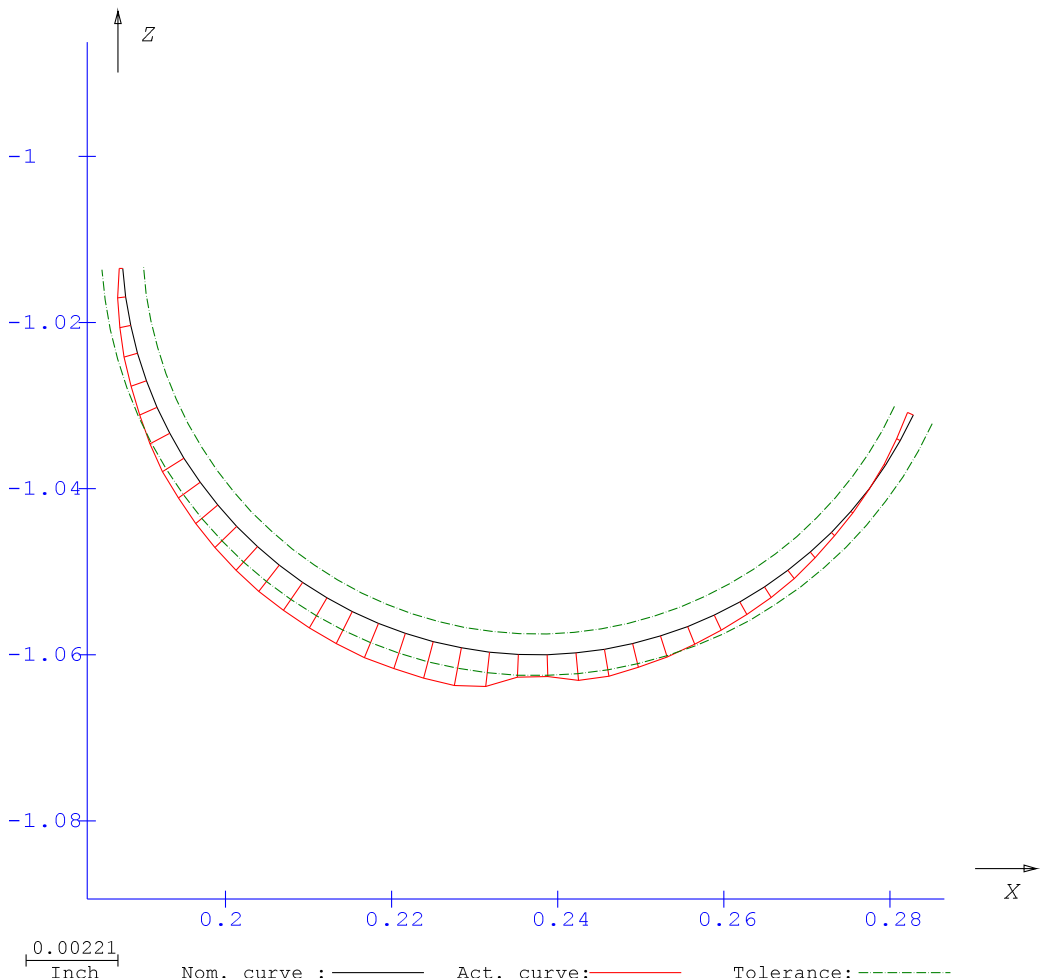
Date: 20-Oct-09, 09:40:45			NO\$NAME			Page 3 of 10	
Text	Eva1.	Actual	Nominal	Up.To1.	Low.To1.	Act-Nom	Graphic
<b>POS_FEATURE(13)</b>		<b>AXI</b>					
	POSITN			0.03000			
	POSMC	0.00921	0.00000	0.03484	0.00000	0.00921	
<b>FEATURE(14)</b>		<b>CYL</b>					
	FORM	0.00028					
	DM	3.49988	3.50000	0.00500	-0.00500	-0.00012	
<b>FEATURE(15)</b>		<b>AXI</b>					
	RADRUN	0.00033	0.00000	0.00100	0.00000	0.00033	
<b>FEATURE(4)</b>		<b>AXI</b>					
	DZ	-0.09702	0.09700	0.00500	-0.00500	0.00002	
<b>FEATURE(5)</b>		<b>CIR</b>					
	FORM	0.00002					
	DM	0.87483	0.87500	0.00500	-0.00500	-0.00017	
<b>POS_FEA(5)</b>		<b>POI</b>					
	POSITN	0.00007	0.00000	0.00500	0.00000	0.00007	
<b>FEATURE(16)</b>		<b>CIR</b>					
	FORM	0.00004					
	DM	0.62578	0.62600	0.00500	-0.00500	-0.00022	
<b>FEATURE(17)</b>		<b>AXI</b>					
	RADRUN	0.00013	0.00000	0.00100	0.00000	0.00013	
<b>FEATURE(18)</b>		<b>CON</b>					
	FORM	0.00003					
	CONANG_2	15.98892	16.00000			-0.01108	
	X	-0.00005	0.00000			0.00005	
	Y	-0.00003	0.00000			0.00003	
<b>FEATURE(19)</b>		<b>POI</b>					
	Z	0.12197	0.12000	0.00500	-0.00500	0.00197	
<b>FEA_20(1)</b>		<b>AXI</b>					
	DY	-0.06091	0.06000	0.01000	-0.01000	0.00091	
<b>POS\$FEA_20(1)</b>		<b>AXI</b>					
	POSITN	0.00217	0.00000	0.01000	0.00000	0.00217	
<b>FEA_20(2)</b>		<b>AXI</b>					
	DX	0.06057	0.06000	0.01000	-0.01000	0.00057	
<b>POS\$FEA_20(2)</b>		<b>AXI</b>					
	POSITN	0.00112	0.00000	0.01000	0.00000	0.00112	
<b>FEA_20(3)</b>		<b>AXI</b>					
	DY	-0.06084	0.06000	0.01000	-0.01000	0.00084	
<b>POS\$FEA_20(3)</b>		<b>AXI</b>					
	POSITN	0.00171	0.00000	0.01000	0.00000	0.00171	
<b>FEA_20(4)</b>		<b>AXI</b>					
	DX	0.06066	0.06000	0.01000	-0.01000	0.00066	
<b>POS\$FEA_20(4)</b>		<b>AXI</b>					
	POSITN	0.00021	0.00000	0.01000	0.00000	0.00021	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEAT_21(1)</b>			<b>AXI</b>				
DZ		0.05986	0.06000	0.00500	-0.00500	-0.00014	
<b>FEAT_21(2)</b>			<b>AXI</b>				
DZ		0.05979	0.06000	0.00500	-0.00500	-0.00021	
<b>FEAT_21(3)</b>			<b>AXI</b>				
DZ		0.05985	0.06000	0.00500	-0.00500	-0.00015	
<b>FEAT_21(4)</b>			<b>AXI</b>				
DZ		0.05995	0.06000	0.00500	-0.00500	-0.00005	
<b>DAT_B_OP</b>			<b>CYL</b>				
DM		0.37507					
FORM		0.00007					
<b>FEATURE(22)</b>			<b>PLA</b>				
FORM		0.00028					
Z		-0.56499					
<b>FEATURE(23)</b>			<b>PLA</b>				
PARALL		0.00032	0.00000	0.00100	0.00000	0.00032	
<b>FEA(24)</b>			<b>PLA</b>				
Z		-1.01076					
FORM		0.00003					
<b>FEATURE(24)</b>			<b>PLA</b>				
PARALL		0.00003	0.00000	0.00100	0.00000	0.00003	
<b>FEATURE(25)</b>			<b>AXI</b>				
DZ		-0.44577	0.44500	0.00100	0.00000	0.00077	
<b>FEATURE(26)</b>			<b>AXI</b>				
Z		-1.01076	1.01000	0.00200	0.00000	0.00076	
<b>FEAT_27(1)</b>			<b>AXI</b>				
DZ		-0.07938	0.08000	0.01000	-0.01000	-0.00062	
<b>FEAT_27(2)</b>			<b>AXI</b>				
DZ		-0.07840	0.08000	0.01000	-0.01000	-0.00160	
<b>FEATURE(28)</b>			<b>CIR</b>				
FORM		0.00010					
DM		2.25072	2.25000	0.01000	-0.01000	0.00072	
<b>FEAT(28)</b>			<b>AXI</b>				
RADRUN		0.00015	0.00000	0.00500	0.00000	0.00015	
<b>FEATURE(30)</b>			<b>CYL</b>				
FORM		0.00006					
DM		0.99747	0.99800	0.00000	-0.01000	-0.00053	
<b>FEATURE(31)</b>			<b>AXI</b>				
RADRUN		0.00008	0.00000	0.00100	0.00000	0.00008	
<b>FEA(36)</b>			<b>CYL</b>				
DM		0.28135	0.28100	0.00500	-0.00500	0.00035	
XY		1.49982	1.50000			-0.00018	
PP_PXPY		-0.19873	0.00000			0.19873	

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEA(36)</b>		<b>CYL</b>					
DM		0.28135	0.28100	0.00500	-0.00500	0.00035	
XY		1.49983	1.50000			-0.00017	
PP_PXPY		-0.19879	0.00000			0.19879	
<b>FEA(37)</b>		<b>CYL</b>					
DM		0.28130	0.28100	0.00500	-0.00500	0.00030	
XY		1.49954	1.50000			-0.00046	
PP_PXPY		44.81246	45.00000			-0.18754	
<b>FEA(38)</b>		<b>CYL</b>					
DM		0.28120	0.28100	0.00500	-0.00500	0.00020	
XY		1.49911	1.50000			-0.00089	
PP_PXPY		89.83562	90.00000			-0.16438	
<b>FEA(39)</b>		<b>CYL</b>					
DM		0.28135	0.28100	0.00500	-0.00500	0.00035	
XY		1.49944	1.50000			-0.00056	
PP_PXPY		134.85783	135.00000			-0.14217	
<b>FEA(40)</b>		<b>CYL</b>					
DM		0.28134	0.28100	0.00500	-0.00500	0.00034	
XY		1.50003	1.50000			0.00003	
PP_PXPY		179.87050	180.00000			-0.12950	
<b>POS_FEATURE(36)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.01043	0.00000	0.03527	0.00000	0.01043	
<b>POS_FEATURE(37)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00994	0.00000	0.03494	0.00000	0.00994	
<b>POS_FEATURE(38)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00880	0.00000	0.03510	0.00000	0.00880	
<b>POS_FEATURE(39)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00759	0.00000	0.03523	0.00000	0.00759	
<b>POS_FEATURE(40)</b>		<b>AXI</b>					
POSITN				0.03000			
POSMC		0.00680	0.00000	0.03523	0.00000	0.00680	
<b>FEATURE(32)</b>		<b>AXI</b>					
RADRUN		0.00016	0.00000	0.00100	0.00000	0.00016	
<b>FEATURE(29)</b>		<b>TOR</b>					
FORM		0.00056					
Cir_RA		0.04968	0.05000	0.00050	-0.00050	-0.00032	
OUT_DM		0.57348	0.57500	0.00100	-0.00100	-0.00152	
INN_DM		0.37476	0.37500			-0.00024	
X		0.00003					
Y		-0.00003					
<b>FEA(33)</b>		<b>PLA</b>					
FORM		0.00005					
Z		-1.06050					

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Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
<b>FEATURE(34)</b>			<b>AXI</b>				
	DZ	0.04974	0.05000	0.00050	-0.00050	-0.00026	
<b>FEATURE(41)</b>			<b>CIR</b>				
	FORM	0.00017					
	RA	0.01674	0.01600	0.00200	-0.00200	0.00074	
<b>FEA_42(1)</b>			<b>AXI</b>				
	Y	-0.20489	0.20000	0.01000	-0.01000	0.00489	
<b>FEA_42(2)</b>			<b>AXI</b>				
	Y	-0.19657	0.20000	0.01000	-0.01000	-0.00343	
<b>FEATURE(43)</b>			<b>CIR</b>				
	RA	0.12855	0.12500	0.00500	-0.00500	0.00355	
<b>FEATURE(44)</b>			<b>CIR</b>				
	FORM	0.00015					
	RA	1.24970	1.25000	0.01000	-0.01000	-0.00030	
<b>FEATURE(45)</b>			<b>POI</b>				
	POSITN	0.00142	0.00000	0.00500	0.00000	0.00142	
<b>FEATURE(46)</b>			<b>CIR</b>				
	FORM	0.00023					
	RA	1.65020	1.65000	0.01000	-0.01000	0.00020	
<b>FEATURE(47)</b>			<b>POI</b>				
	POSITN	0.00164	0.00000	0.00500	0.00000	0.00164	

Text	Eval.	Actual	Nominal	Up.Tol.	Low.Tol.	Act-Nom	Graphic
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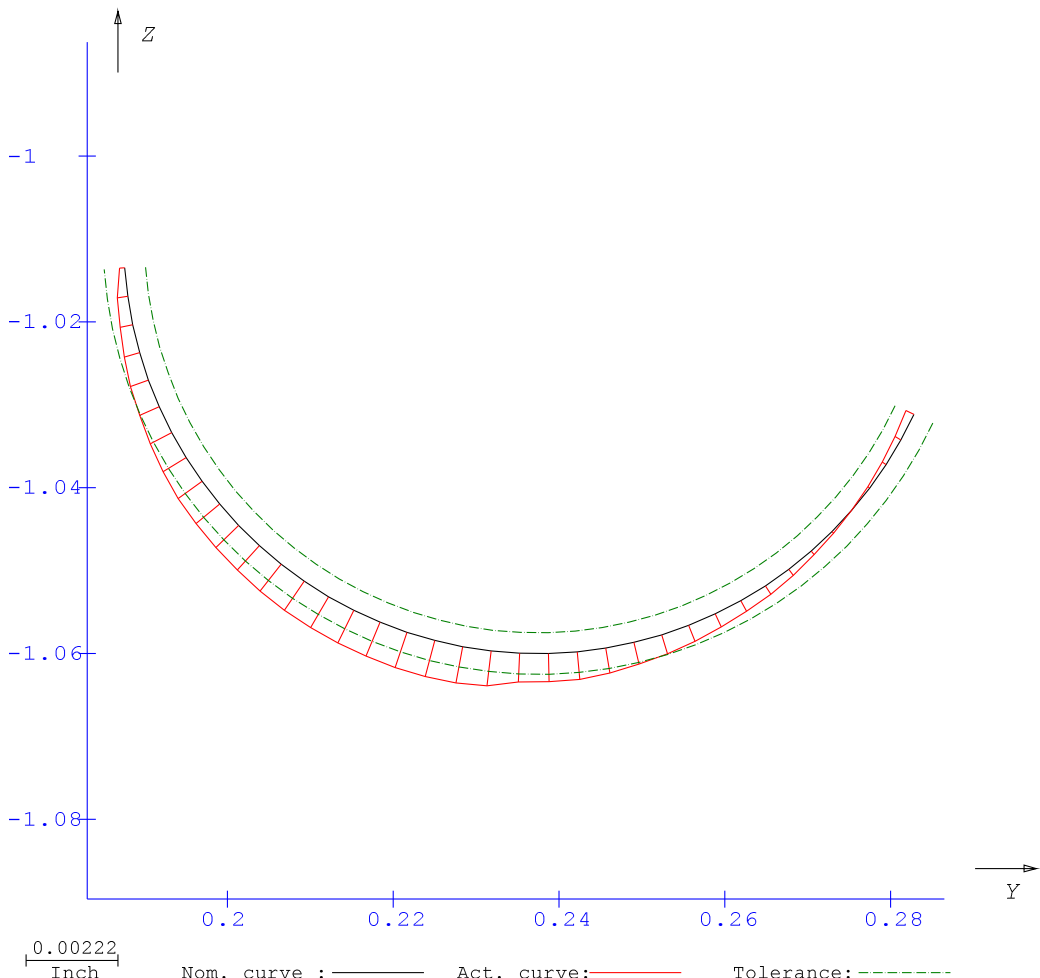
Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 007      Part No. :      Department: MET. QUALITY IN  
 Element : FEATURE\_29(1)

		X	Y	Z	Nr.	
Form .....	0.00107	Min. Deviat.:-0.00092	0.22838	0.00000	-1.05916	20
Lower Toler. :	-0.00050	Max. Deviat.: 0.00015	0.28282	0.00000	-1.03113	1
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 0°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban  
 Date .....:20-OCT-2009  
 Time .....:09:40:45



Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 007                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(2)

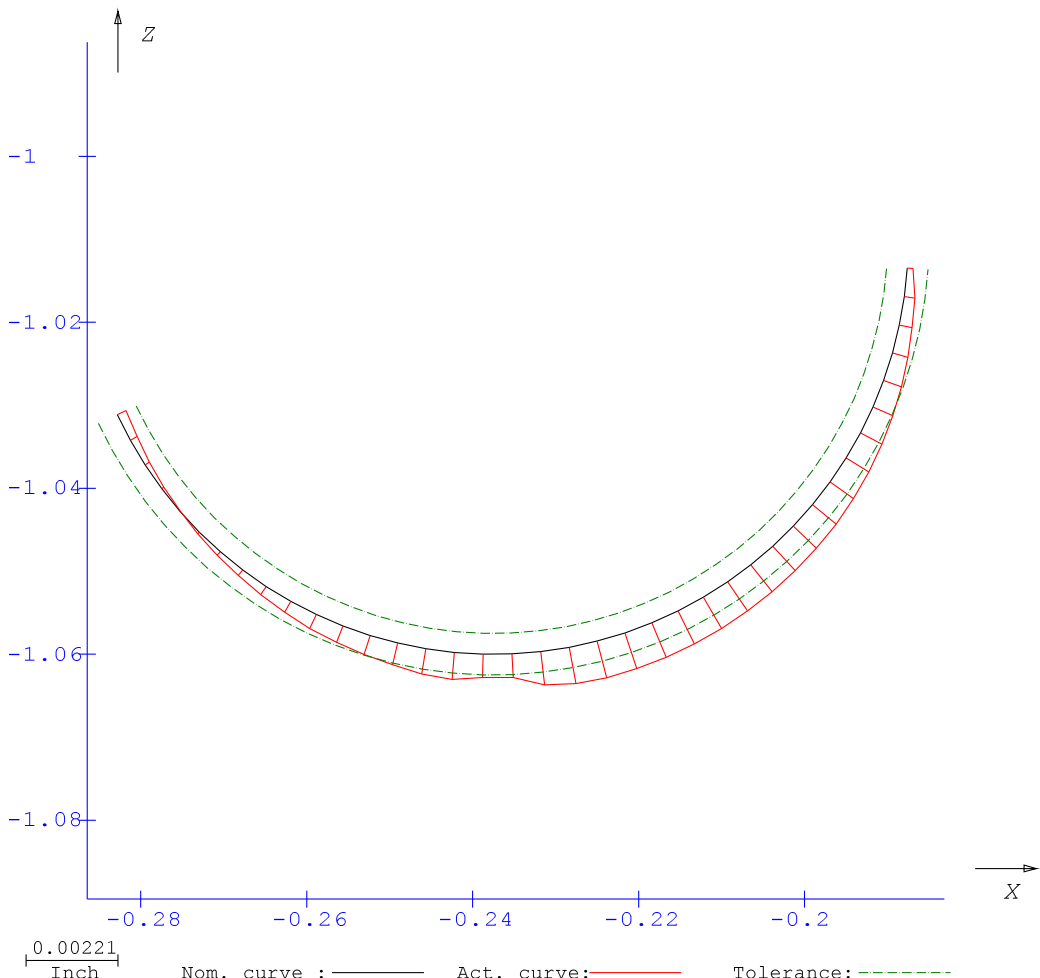
		X	Y	Z	Nr.		
Form .....	0.00111	Min. Deviat.:-0.00021	0.00000	0.28282	-1.03113	1	
Lower Toler. :	-0.00050	Max. Deviat.:	0.00090	0.00000	0.22499	-1.05841	21
Upper Toler. :	0.00050	Profile of Radius 0.0500					
Error Magnif.:	5	@ 90°					
No. of points:	39						



## 2D - CONTOUR

Inspector.:kcaban  
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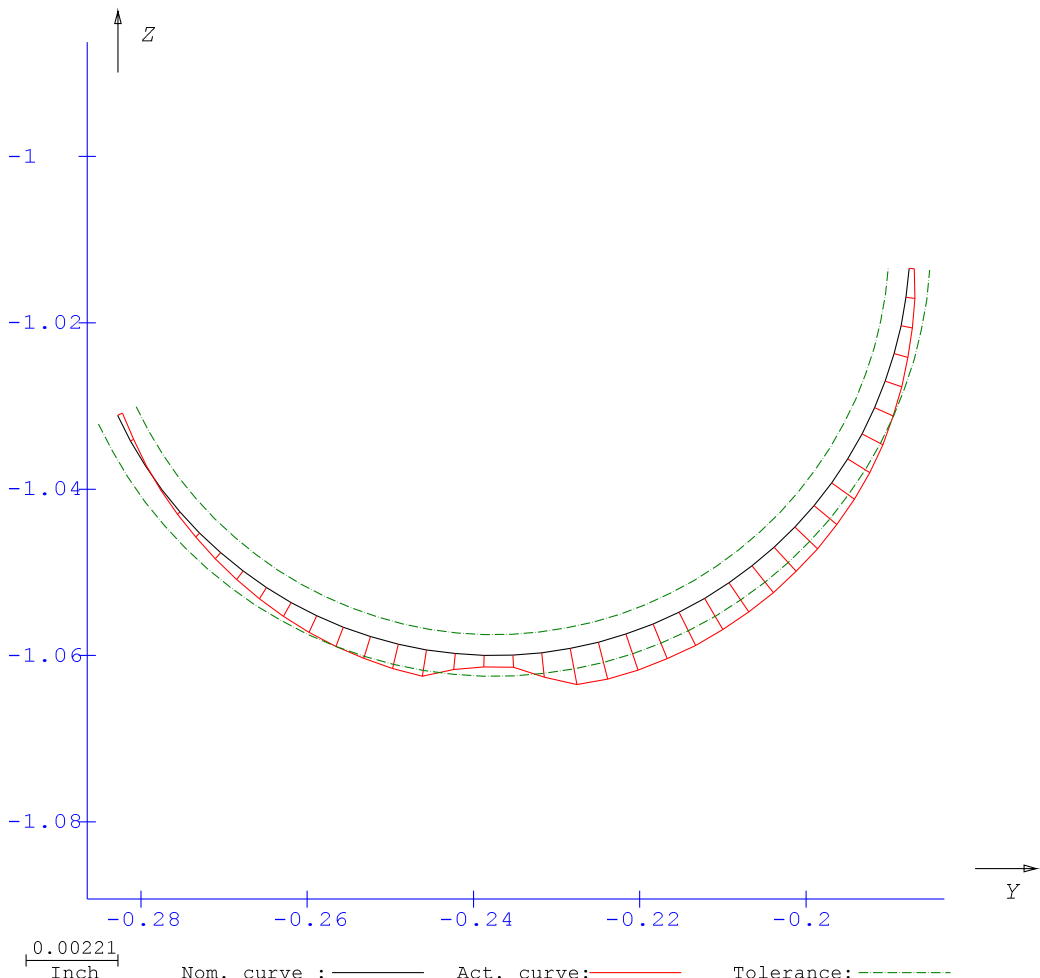
Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 007                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(3)

		X	Y	Z	Nr.	
Form .....	0.00114	Min. Deviat.:-0.00023	-0.28282	0.00000	-1.03113	1
Lower Toler. :	-0.00050	Max. Deviat.: 0.00091	-0.22499	0.00000	-1.05841	21
Upper Toler. :	0.00050	Profile of Radius 0.0500				
Error Magnif.:	5	@ 180°				
No. of points:	39					



2D - CONTOUR

Inspector.:kcaban  
 Date .....:20-OCT-2009  
 Time .....:09:40:45



Notation : DRIFT TUBE 1      Producer : L. GARCIA      Draw. No. : PF-700-913-11 R  
 Ser. No. : 007                      Part No. :                      Department: MET. QUALITY IN  
 Element : FEATURE\_29(4)

		X	Y	Z	Nr.
Form .....	0.00105	0.00000	-0.28282	-1.03113	1
Lower Toler. :	-0.00050	0.00000	-0.22499	-1.05841	21
Upper Toler. :	0.00050				
Error Magnif.:	5				
No. of points:	39				

Min. Deviat.: -0.00014      Profile of Radius 0.0500  
 Max. Deviat.: 0.00092      @ 270°



2D - CONTOUR

Inspector.:kcaban  
 Date .....:20-OCT-2009  
 Time .....:09:40:45